

Date: Wednesday, 30/04/2008 6:56:21 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: DOOR ASSEMBLY		
Job Number	: 38894			Part Number	: D3213041		
Estimate Number	: 10713			Drawing Number	: D3213 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/04/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 05/05/2008 Qty: 2 Um: Each		
Previous Run	: 38820						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 05-11-17 17:27						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31613	Hinge 15.0"		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 2 D3161-3 Hinge <u>B388334X2</u>				
2.0	D32131	Door Panel		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D3213-1 Door <u>B38834</u> X2 ✓ ml				
3.0	D32133	Door Panel		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D3213-3 Door <u>B38836</u> X2 ✓ ml				
4.0	MS20470AD44	Rivet, Universal Head		
Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 24 MS20470AD4-4 Rivet <u>M106552</u> ✓ ml <u>08/05/01</u>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 30/04/2008 6:56:21 AM
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Part Number: D3213041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

X2

ml 08/05/01

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/01 X2

7.0 POWDER COATING

POWDER COATING



M 100700

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 10:30 AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:00 AM

10 08-05-01

08-05-01

X2

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M-f

08/05/01

QX

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D2137 Decal	B37068	

✓ ml

10.0 D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number	Description	Batch
1 D2419 Handle	B37069	

✓ ml
08/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	D2462	Seal
		Comment: Qty.: 2.4000 f(s)/Unit Total : 4.8000 f(s) Pick: Assembly Kit Qty Part Number Description Batch 2 D2462 Seal <u>B37747</u>
12.0	D27281	Dart Logo Label - small
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2728-1 Decal <u>B24215</u>
13.0	AN960JD6	Washer
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 AN960JD6 Washer <u>M6085</u>
14.0	MS20470AD46	Rivet, Universal Head
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 MS20470AD4-6 Rivet <u>107082</u>
15.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3213041 <i>mlo8/05/01</i>
16.0	QC5	INSPECT WORK TO CURRENT STEP
		Comment: INSPECT WORK TO CURRENT STEP <i>S 08/05/01 (x2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

L 8894 1 2

18.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05 *[Signature]*

Job Completion

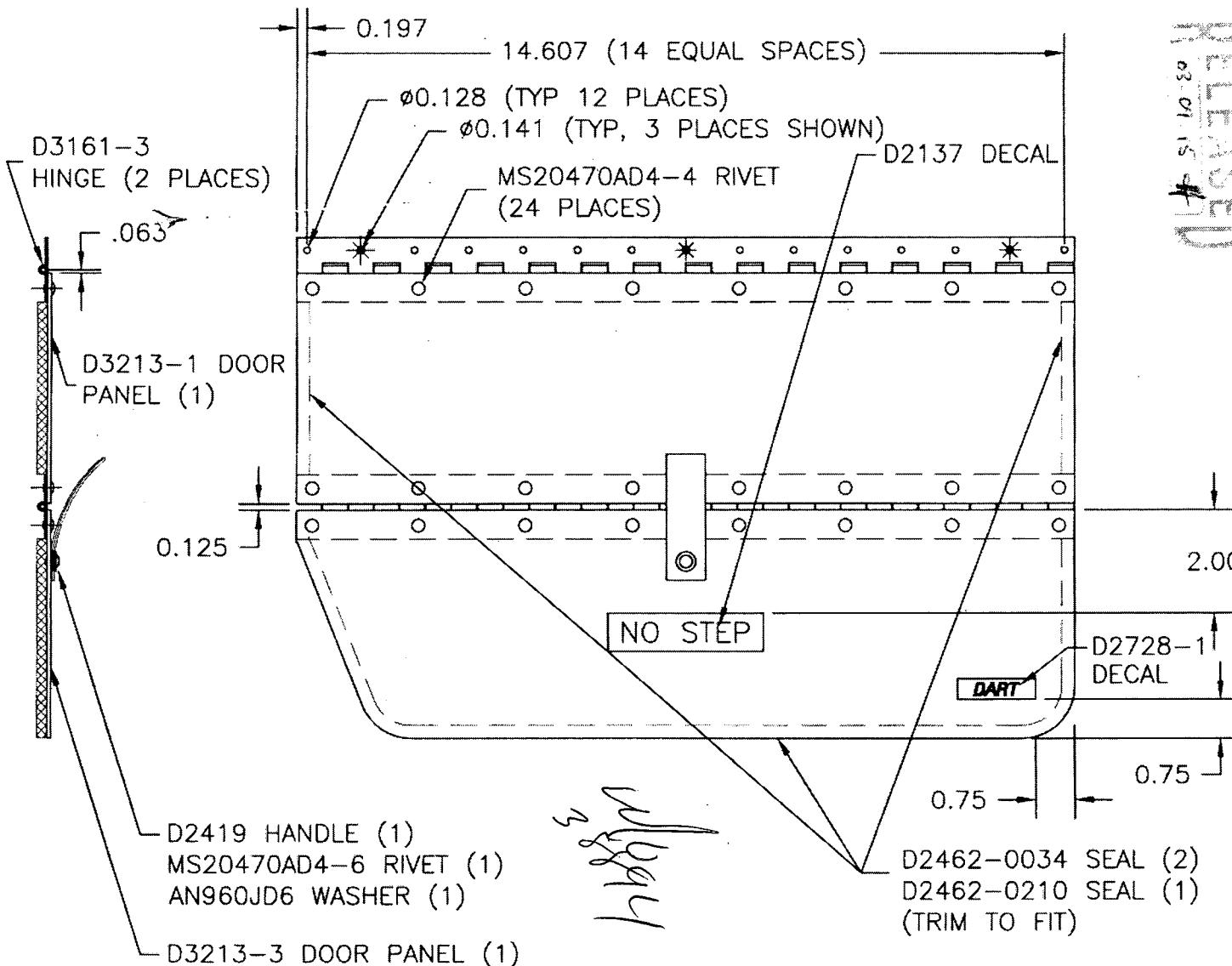


MF 08-05-01

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3213
DATE	03.09.03	TITLE
	03.09.03	DOOR ASSEMBLY
A	03.09.03	NEW ISSUE



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

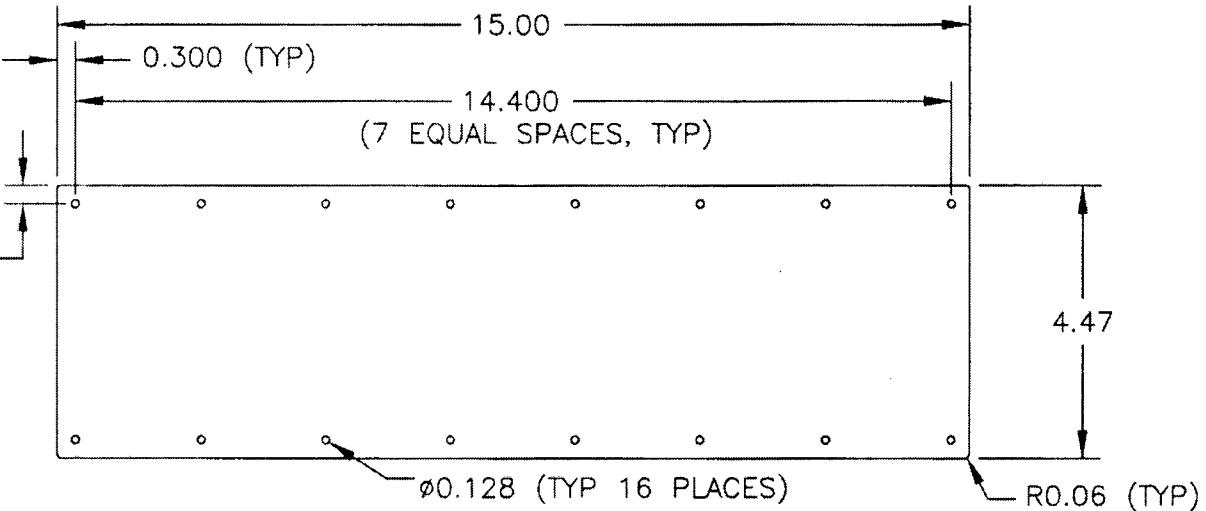
FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

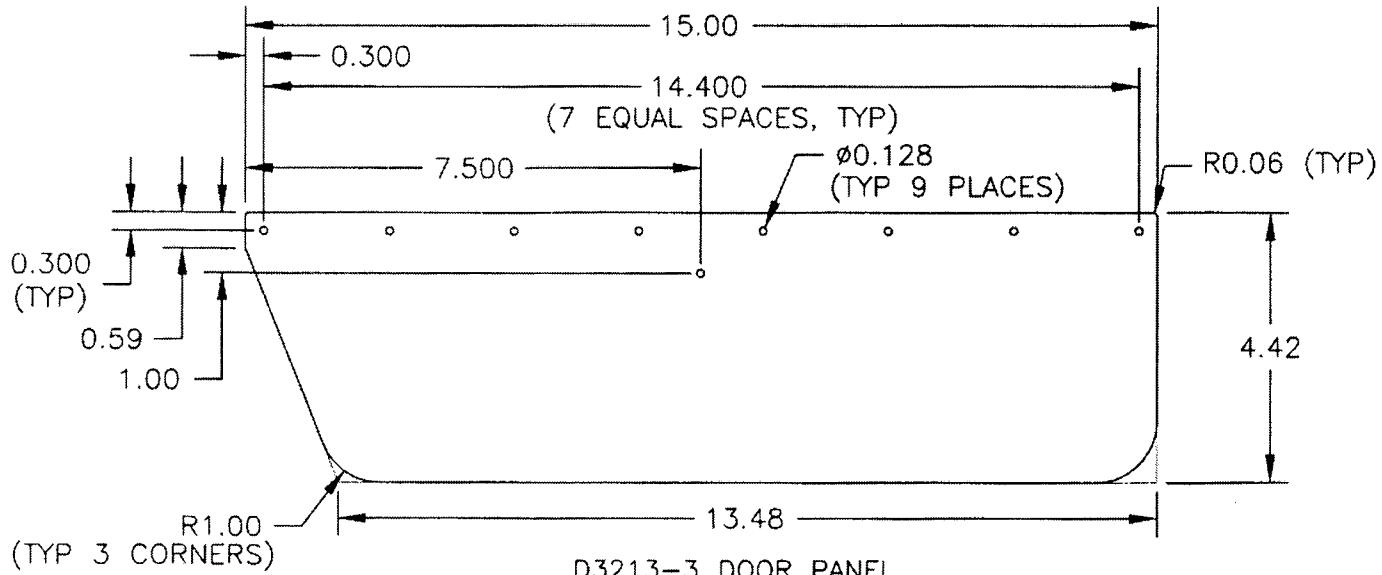
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3213
DATE 03.09.03		REV. A 2 OF 2 TITLE DOOR ASSEMBLY SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

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